

Date: Friday, 11/17/2006 9:07:52 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 29510		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/17/2006 S.O. No. : N/A		Drawing Revision	: E		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/5/2006 Qty: 16 Um: Each		
Previous Run	: 29159					
Written By	: <u>DA</u> 06/11/09					
Checked & Approved By	: <u>DA</u> 06/11/09					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					
Additional Product						
Job Number:						
Seq. #:	Machine Or Operation:	Description :				
1.0	D6101007	7075-T7351 8.25X7.75X2.5 				
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B25353</u></p>						
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 				
<p>Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>29510</u> Double check by: <u>SD</u></p> <p>1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets ✓ 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets ✓ 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.</p> <p><u>SD / mkl / En 06/11/29 - 10</u></p>						
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 				
<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572</p> <p><u>mkl / En 06/11/29 - 10</u></p>						
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 				
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p><u>SD / mkl / En 06/11/29 - 10</u></p>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 11/17/2006 9:07:53 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 29510

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

3.1 06/12/10 16

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06/12/18

16

7.0 POWDER COATING POWDER COATING



M102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.R/a.m 06/12/10 16

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



10/12/18 16

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



10/12/18 16



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57971

10/12/18 16

16

10.0 QC21 FINAL INSPECTION/W/O RELEASE



10/12/19 16

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/12/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order: 29510
Description: Saddle, Fwd Outboard			Part Number: D2571
Inspection Dwg: D2571 Rev. E			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.999	7.998	7.998		
F	0.490	0.510		.496	0.503	0.502	0.502		
G	0.257	0.262	DT8683	.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	.377	0.376	0.376	0.376		
I	0.490	0.510		.497	0.498	0.500	0.500		
J	1.174	1.184		1.179	1.178	1.178	1.179		
K	0.558	0.578		.568	0.564	0.567	0.569		
L	1.174	1.184		1.179	1.178	1.178	1.179		
M	1.490	1.500		1.495	1.494	1.496	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.872	3.872	3.872		
P	0.115	0.135		.125	0.126	0.126	0.127		
Q	0.115	0.135		.135	0.135	0.135	0.135		
R	0.240	0.260		.250	0.251	0.251	0.251		
S	0.115	0.135		.128	0.130	0.129	0.132		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	2.940	2.980		2.959	2.966	2.961	2.961		
V	0.230	0.250		.242	0.242	0.242	0.246		
W	0.115	0.135		.123	0.129	0.129	0.130		
X	0.308	0.313		.312	0.312	0.312	0.312		
Y	0.760	0.765		.761	0.761	0.761	0.761		
Z	0.352	0.372		.364	0.360	0.365	0.366		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		.624	0.632	0.632	0.632		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.252	0.252	0.254	0.247		
AE	1.375	1.395		1.386	1.385	1.385	1.386		
AF	0.115	0.135		.133	0.122	0.130	0.130		
AG	0.240	0.280		.245	0.260	0.263	0.263		
AH	0.240	0.260		.250	0.251	0.251	0.250		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SL	1/9/11	Audited by:	SL
Date:	06/11/24 / 06/11/27		Date:	06/12/10.

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	SL

DART AEROSPACE LTD				Work Order:	29510
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DE5000	0.440	0.439	0.439	0.440		
B	1.745	1.755		1.756	1.750	1.748	1.750		
C	3.495	3.505		3.506	3.506	3.500	3.506		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.998	7.999	7.998		
F	0.490	0.510		0.503	0.503	0.503	0.500		
G	0.257	0.262	DE5000	0.258	0.258	0.258	0.258		
H	0.375	0.380	DE5000	0.376	0.376	0.376	0.377		
I	0.490	0.510		0.499	0.499	0.500	0.498		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.567	0.566	0.565		
L	1.174	1.184		1.178	1.178	1.178	1.178		
M	1.490	1.500		1.497	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	3.869	3.879		3.874	3.872	3.872	3.873		
P	0.115	0.135		0.127	0.127	0.128	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.130	0.130	0.131	0.131		
T	0.178	0.198		0.183	0.183	0.183	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.240	0.241	0.240		
W	0.115	0.135		0.126	0.127	0.127	0.127		
X	0.308	0.313		0.312	0.312	0.312	0.312		
Y	0.760	0.765		0.761	0.761	0.761	0.761		
Z	0.352	0.372		0.364	0.364	0.364	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.633	0.633	0.633	0.635		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.251	0.248	0.250		
AE	1.375	1.395		1.386	1.386	1.387	1.387		
AF	0.115	0.135		0.125	0.125	0.128	0.132		
AG	0.240	0.280		0.256	0.258	0.254	0.266		
AH	0.240	0.260		0.250	0.250	0.249	0.250		
AI	2.000	2.020		2.000	2.000	2.003	2.001		
AJ	0.023	0.043		0.036	0.030	0.030	0.036		
Accept/Reject									

Measured by:	<i>Onf</i>	Audited by:	<i>J.L</i>
Date:	<i>06/11/12</i>	Date:	<i>06/10/12</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>JK</i> <i>gall</i>	

DART AEROSPACE LTD		Work Order:	29510
Description: Saddle, Fwd Outboard		Part Number:	D2571
Inspection Dwg: D2571 Rev. E			Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.439	.439	.439	.446		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.501		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.999	8.000	8.000	8.002		
F	0.490	0.510		.495	.495	.496	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.377		
I	0.490	0.510		.499	.499	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.568	.564		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.493	1.493	1.493	1.492		
N	2.495	2.505		2.500	2.500	2.500	2.495		
O	3.869	3.879		3.874	3.874	3.874	3.872		
P	0.115	0.135		.126	.127	.127	.122		
Q	0.115	0.135		.133	.135	.135	.135		
R	0.240	0.260		.250	.251	.251	.251		
S	0.115	0.135		.130	.129	.129	.126		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.962		
V	0.230	0.250		.240	.240	.238	.238		
W	0.115	0.135		.125	.122	.123	.124		
X	0.308	0.313		.311	.311	.311	.310		
Y	0.760	0.765		.761	.761	.761	.765		
Z	0.352	0.372		.363	.363	.363	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.624	.623	.629		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.248	.248	.247		
AE	1.375	1.395		1.386	1.387	1.389	1.387		
AF	0.115	0.135		.134	.134	.134	.135		
AG	0.240	0.280		.250	.250	.257	.260		
AH	0.240	0.260		.249	.248	.248	.248		
AI	2.000	2.020		2.001	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.030		
Accept/Reject									

Measured by:	SD	/	SP	Audited by:	JL
Date:	06/11/28	/	06/11/29	Date:	06/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL

DART AEROSPACE LTD				Work Order:	29510
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

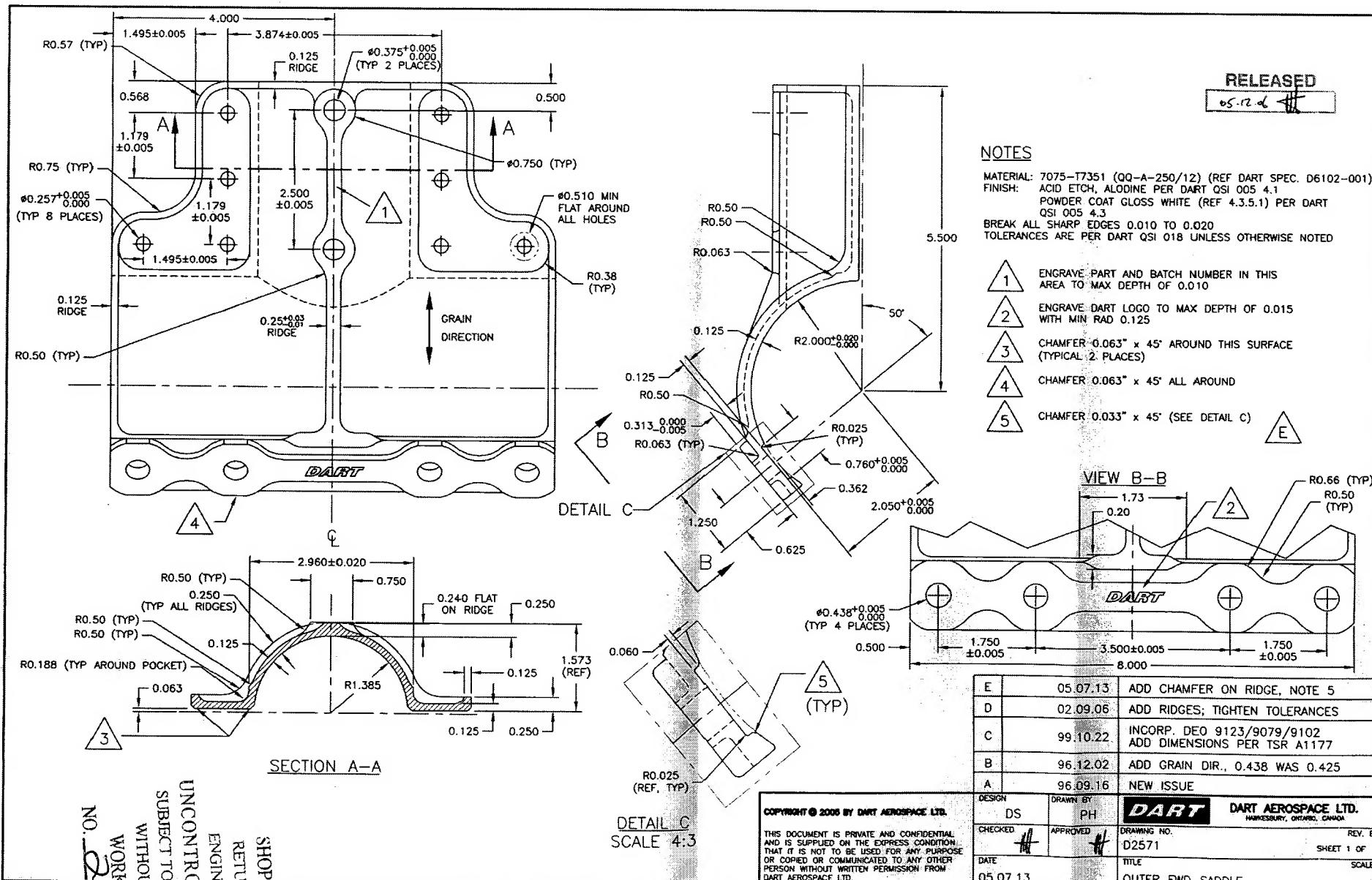
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	-DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.749	1.750	1.751	1.746		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.745	1.750	1.751	1.746		
E	7.990	8.010		8.002	8.003	8.003	8.003		
F	0.490	0.510		0.500	0.500	0.500	0.499		
G	0.257	0.262	-DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	-DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.500	0.499	0.498	0.502		
J	1.174	1.184		1.175	1.176	1.176	1.176		
K	0.558	0.578		0.566	0.565	0.562	0.566		
L	1.174	1.184		1.175	1.176	1.176	1.176		
M	1.490	1.500		1.493	1.493	1.494	1.495		
N	2.495	2.505		2.493	2.500	2.497	2.497		
O	3.869	3.879		3.872	3.872	3.873	3.870		
P	0.115	0.135		0.127	0.127	0.126	0.126		
Q	0.115	0.135		0.135	0.137	0.135	0.135		
R	0.240	0.260		0.252	0.251	0.251	0.251		
S	0.115	0.135		0.179	0.178	0.179	0.179		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.964	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.237	0.240	0.239		
W	0.115	0.135		0.122	0.123	0.123	0.123		
X	0.308	0.313		0.310	0.310	0.311	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.365	0.362	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.627	0.628	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.250	0.246	0.246		
AE	1.375	1.395		1.388	1.387	1.386	1.387		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.247	0.253	0.248		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:		Audited by:	
Date:	06/11/28	Date:	06/11/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



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WORK ORDER NO. 29510
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DESIGN	DRAWN BY	DART		DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
DS	PH			REV. E
CHECKED	APPROVED			DRAWING NO. D2571
				SHEET 1 OF 1
DATE				TITLE
05.07.13				OUTER FWD SADDLE
				SCALE 2:3